

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007282**Date Inspected:** 31-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG cross beam CB3 (in superstructure trial assembly)

This QA observed that ZPMC personnel have commenced base metal weld repairs on crossbeam CB3 splice plate X202E without the Engineers approval. The areas being repaired were previously damaged while removing temporary tack welds joining this plate to the bottom panels of the crossbeam (CB3) and OBG segment 4BW. The splice plate is designated as SPCM. See attached photos. AWS D1.5 2002 section 3.3.7.3 states "Tack welds not incorporated into the final weld shall be removed in such a manner that the base metal is not nicked or undercut. Repair of base metal accidentally removed shall be approved by the Engineer prior to making the repair. This QA notified ZPMC QA identified as Mr. Wang Lu and ABF QA inspector identified as Mr. Li Jing Bo of this non conformance and informed both that an incident report would be generated for this issue.

OBG cross beam CB5

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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### OBG cross beam CB6

This QA observed that no significant work was being performed on this crossbeam during the time this QA was present.

### OBG cross beam CB7

This QA observed ZPMC personnel back gouging Complete Joint Penetration (CJP) welds connecting web to flange gussets on floorbeam diaphragm identified as FB204. No other significant work was observed during the time this QA was present.

### OBG cross beam CB8

This QA observed ZPMC personnel preparing to splice bottom panels together for the above mentioned crossbeam. Preparation included beveling, grinding and fitting the panels together. No other significant work was observed during the time this QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

As mentioned above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

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**Inspected By:** Hall, Steven

Quality Assurance Inspector

**Reviewed By:** Prue, Erik

QA Reviewer

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